

Date: Wednesday, 12/5/2007 10:38:27 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: SEAT PAN		
Job Number	36148					
Estimate Number	11092		Part Number	: D30221		
P.O. Number			Drawing Number	: D3022 REV A		
This Issue	12/5/2007	S.O. No. :	Project Number	: N/A		
Prsht Rev.	NC		Drawing Revision	: A		
First Issue	/ /	Type : MACHINED PARTS	Material	:		
Previous Run	34897		Due Date	1/10/2008	Qty:	1 Um: Each
Written By	<u>Johnston</u>					
Checked & Approved By						
Comment	Est.	02.01.23	Revised	NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
Comment: Qty.: 1.7044 sf(s)/Unit Total : 1.7044 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" Batch: <u>M100272</u> PD 08-01-15 (1)		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut seat pan (32.00" x 14.75") as per template D3022-1T1 & Dwg D3022. 2-Deburr PD 08-01-15 (1)		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP 10/01/15 (1)		
4.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per Dwg D3022 SB 08/01/15 (1)		
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Transfer drill Seat Pan From Frame 2-Deburr PD 08-01-16 PTO		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/15	H.1	Qc S					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/01/23 (1)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-04

8.0 POWDER COATING

POWDER COATING



M 106 442

(X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 08/8/05

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-05

(X)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 08-02-07

(1)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/08/05

Job Completion



in 2008/2/08

(1)

W

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

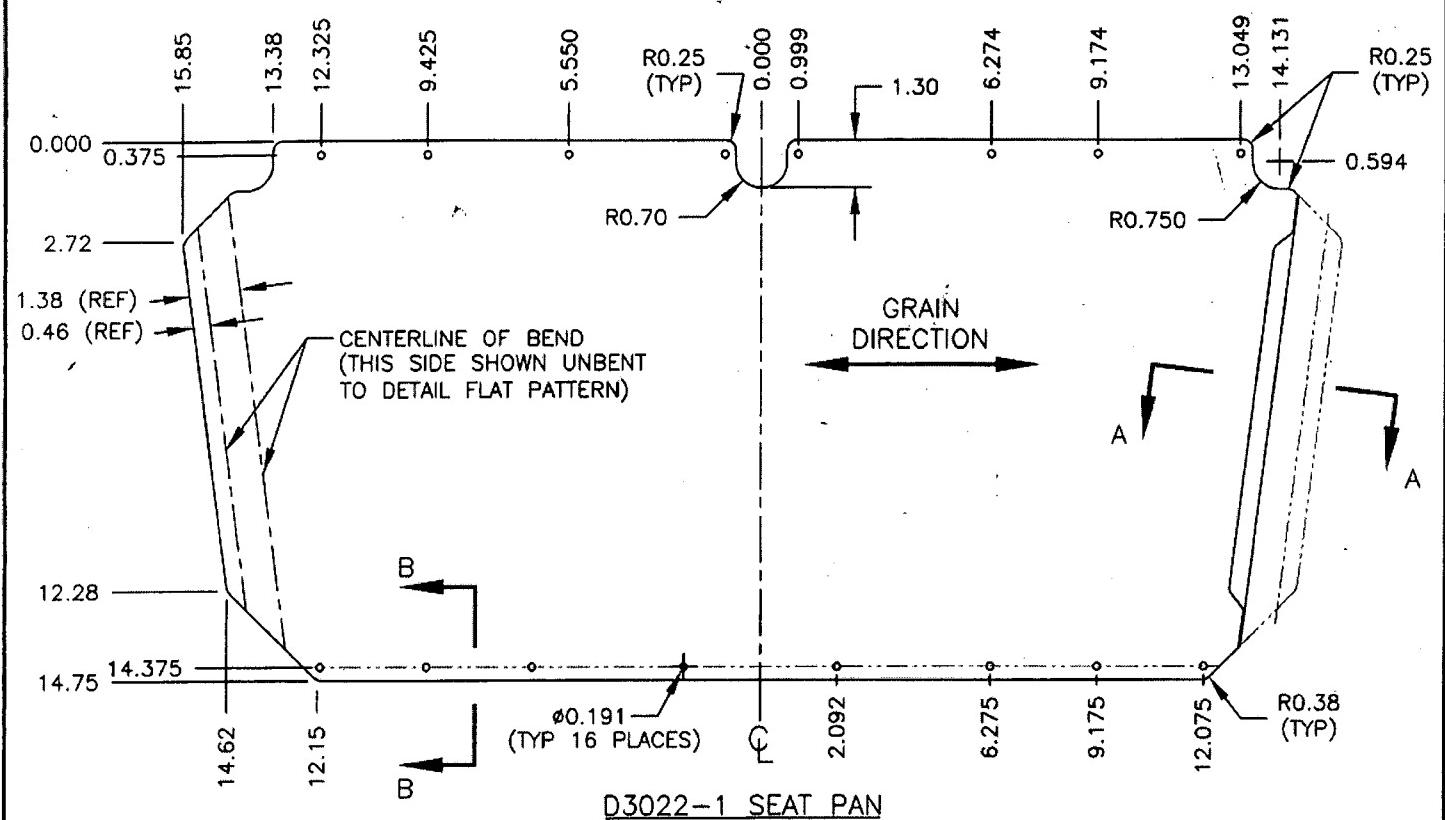
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

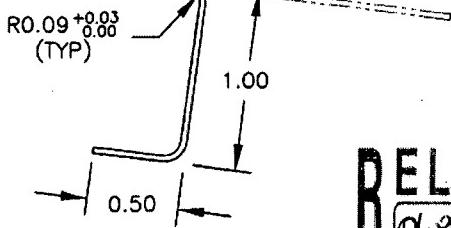
DART



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3022	REV. A SHEET 1 OF 1
DATE 01.05.18	TITLE SEAT PAN	SCALE 1:5	
A	01.05.18	NEW ISSUE	

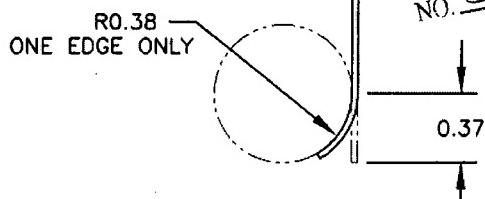


SECTION A-A



RELEASED
01.06.07

SECTION B-B



NOTES:

- 1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36148